

Date: Wednesday, 4/26/2006 8:42:06 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 24866		
Estimate Number	: 10469		
P.O. Number	: N/A	Part Number	: D3391023
This Issue	: 4/26/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3391 REV C
First Issue	: 11/18/2005	Project Number	: N/A
Previous Run	: 24442	Drawing Revision	: C
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/20/2005
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	1/5 Um: Each
Comment	: Est. A 05.10.20 New Issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	B24593

DP 06-4-7

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.438" as per Dwg D3391

7-Remove indexing ridge on aft end of skidtube as per Dwg D3391

8-Deburr

9-Drill #30 pilot holes using wearplate Jig DT8217/Identify Ø0.208" holes with paint marker

10-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg D3391

11-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

12-Deburr and blow out all chips from inside tube

DP 06-4-7

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 8:42:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *a.m 06-04-25* *Q*

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/25 1

6.0 D33891 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

WEB

Pick:

Qty	Part Number	Description	Batch
1	D3389-1	Web	<i>26589</i>
A/R		Sikaflex-241/-291	<i>19134</i>
		Sikaflex expire date:	<i>06-06-20</i>

Start: _____ Time: _____

Finish: _____ Time: _____

Plm' 06-04-25 (1)

7.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

8.0 NAS1330C3KB116 Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
20	NAS1330C3KB116	Insert	<i>119349</i>

9.0 NAS1330C3KB166



Comment: Qty.: 10.0000 Each(s)/Unit Total : 50.0000 Each(s)

RivnuT

Pick:

Qty	Part Number	Description	Batch
10	NAS1330C3KB166	Insert	<i>M100732</i>

DL 06/04/26 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 8/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 8:42:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
Install inserts as per Dwg D3391

DL 04/04/26 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Use paint screws to mask inserts.

DL 04/04/26 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

04/09/25 1

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: N/A

DL 04/04/26 (1)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

04/05/02 (1)

Job Completion



U 04/05/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries